

Date: Thursday, 16/11/2006 9:46:51 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 29382D		
Estimate Number	: 10296		
P.O. Number	: N/A	Part Number	: D32203
This Issue	: 16/11/2006 S.O. No. : N/A	Drawing Number	: D3220 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 09/11/2006 Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 24956D	Material	: N/A
Written By	: <u>U</u>	Due Date	: 05/12/2006
Checked & Approved By	: <u>U</u>	Qty:	17 Um: Each
Comment	: Est Rev: A New Issue 05-11-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.6233 sf(s)/Unit Total : 9.9725 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
(M2024T3S.050  
Identify for D3220-3  
Batch: M19053

SAD 06:11:25

17

2.0	WATER JET	FLOW WATER JET
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Dwg: A1  
Pro: A1



Comment: FLOW WATER JET

SAD 06:11:25

17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:11:25

17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 06/11/27

(17)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

06/11/30 X 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 04/12/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/11/2006 9:46:52 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 29382D

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/06/12/04 (17)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5793

11/06/12/05

(17)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/06/12/05 (17)

Job Completion



11/06/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

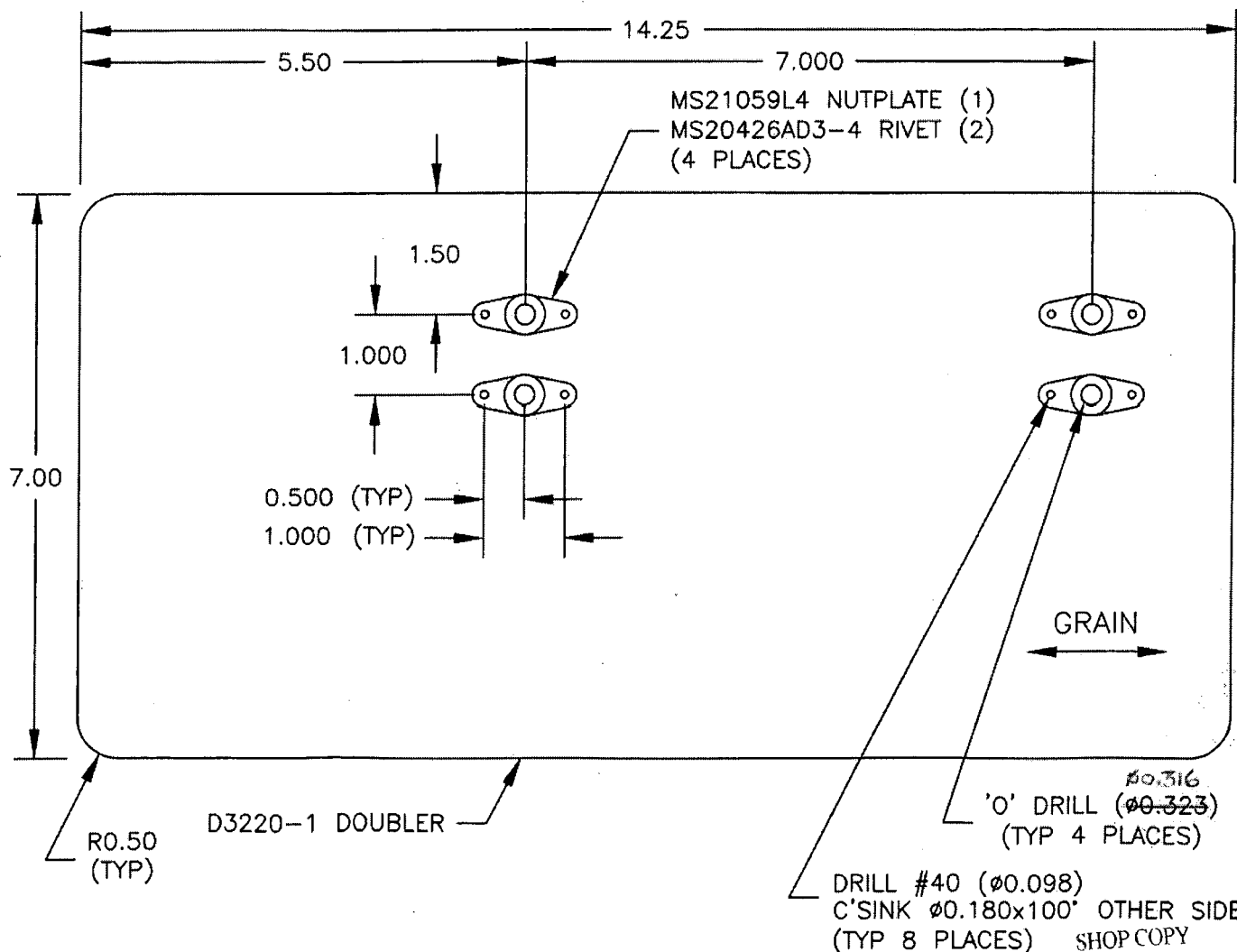
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3220	REV. A SHEET 1 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2
A	03.10.16	NEW ISSUE	
AI	03.11.13	CORRECTED DIM	

RELEASED  
03.11.14 **D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 29382D

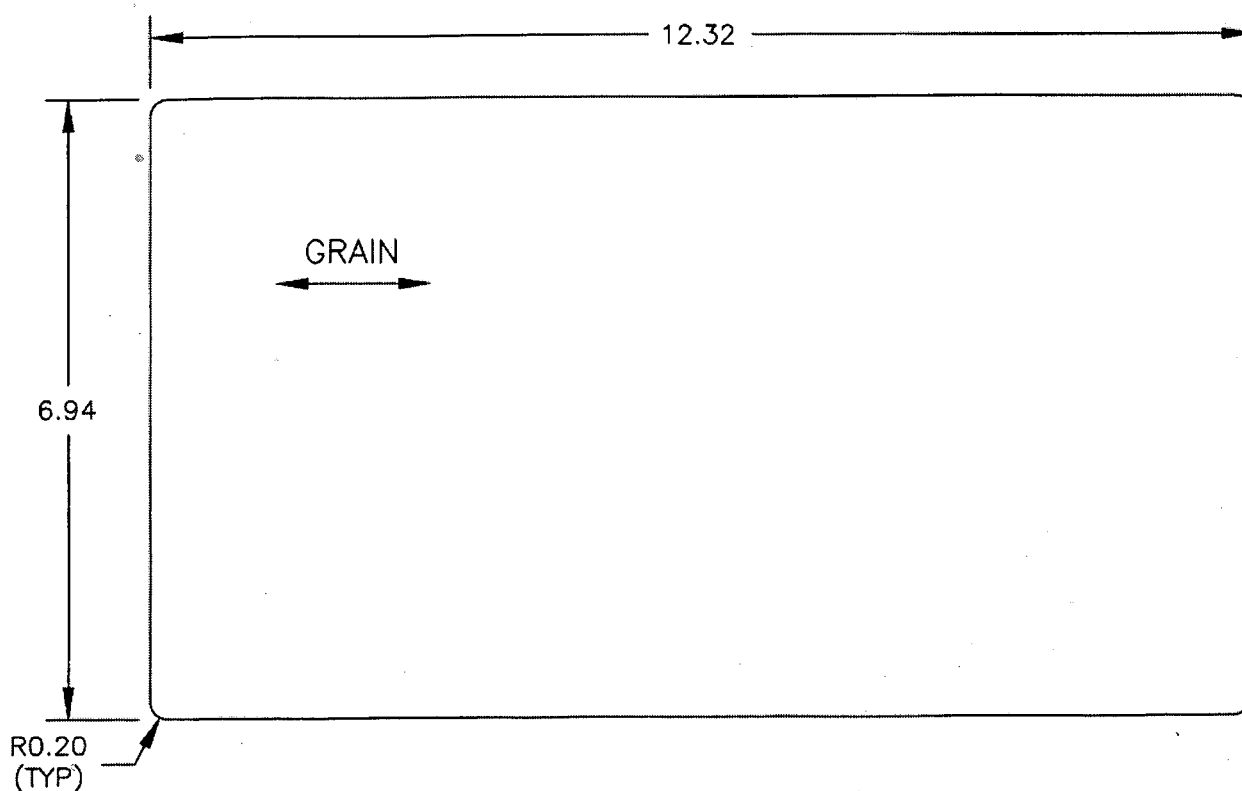
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DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED  
03.11.14 *[Signature]*



### D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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NO. 29382D

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